

Work Order ID 79026

79026

Page 1

January-18-12 3:14:59 PM

Item ID: D4030-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: , Stop ***NS2***
 Item Name: Long Basket Assembly (350)
 Start Date: 18/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 01/02/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MCJ Date: 12/01/18 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4030	C

100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									

PC 12/2/7

110	Assemble as per dwg	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing	****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****								

1 BK 12-2-8.

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

81212108 (#)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 18/01/2012 **Start Qty:** 1.00 *** 1 ***

Cust Item ID:

Required Date: 01/02/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

Accept Qty

Reject
QtyReject
Number

**Insp.
Stamp**

130

Identify as per dwg & Stock Location: _____

0.00


130

Memo

0.00

Packaging

Packaging

0.00  79023

12/29/58

140

QC21- Final Inspection - Work Order Release

0.00

140

Memo

0.00

QC

Quality Control

12/2/13

12-02-16
①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 79026

79026

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg
revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-210 *D4086-210* Placard, Max Load		Manufactured	No				Each	8.0000		1			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST122				7					
				66275				1					
				76298				6		76298			
				ST124				1					
				64869				1					
D2530 *D2530* Handle Weldment		Manufactured	No			100	Each	14.0000	1	1			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST506				14					
				76087				4		76087			
				77030				10					
D2535 *D2535* Spring		Manufactured	No			100	Each	68.0000	2	2			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST504				68					
				71117				18		71117			
				77488				50					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2537 Manufactured No

100 Each

26.0000

2

2

**

D2537

Bushing

Location

Loc Qty

Loc Code

ST504

26

76088

26

D3913-041 Manufactured No

100 Each

0.0000

1

1

**

D3913-041

Long Basket Base Assembly, 350

D3914-041

Manufactured No

100 Each

0.0000

1

1

**

D3914-041

Long Basket Lid Assembly (350)

D3917-3

Manufactured No

100 Each

17.0000

6

6

**

D3917-3

Washer

Location

Loc Qty

Loc Code

ST070

17

76956

17

D3953-3 Manufactured No

100 Each

34.0000

2

2

**

D3953-3

Gas Spring Stud, Lid

Location

Loc Qty

Loc Code

ST075

34

76659

14

78042

20

76659

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-7 Manufactured No

100 Each 22.0000 2 2

D3953-7

Spring Spacer

**

Location

Loc Qty

Loc Code

ST075

22

76295

22

76295

D3953-9 Manufactured No

100 Each 6.0000 2 2

D3953-9

Gas Spring Washer

**

Location

Loc Qty

Loc Code

ST075

6

76296

6

76296

D3953-17 Manufactured No

100 Each 15.0000 2 2

D3953-17

Gas Spring Spacer

**

Location

Loc Qty

Loc Code

ST075

15

76294

15

76294

D3953-19 Manufactured No

100 Each 18.0000 1 1

D3953-19

Gas Spring Bracket

**

Location

Loc Qty

Loc Code

ST075

18

75227

18

75227

D3953-21 Manufactured No

100 Each 5.0000 1 1

D3953-21

Gas Spring Bracket

**

Location

Loc Qty

Loc Code

ST075

5

73557

5

73557

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 79026

79026

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3969-3 Manufactured No

100 Each

19.0000 1 1

D3969-3

Spring (Basket Lid)

**

[Handwritten signature]

Location

Loc Qty

Loc Code

ST272

19

64285

1

73515

18

73515

AN3-14A Purchased No

100 Each

116.0000 4 4

AN3-14A

Bolt

**

[Handwritten signature]

Location

Loc Qty

Loc Code

ST352

116

117872

16

119328

100

117872

AN3-16A Purchased No

100 Each

109.0000 2 2

AN3-16A

Bolt

**

[Handwritten signature]

Location

Loc Qty

Loc Code

ST352

109

117441

49

118628

60

118628

AN5-17A Purchased No

100 Each

80.0000 4 4

AN5-17A

Bolt

**

[Handwritten signature] 12/2/10

Location

Loc Qty

Loc Code

FP001

38

119438

38

ST338

42

117872

42

119438

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 79026

79026

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN4-12 Purchased No

100 Each 53.0000 3 3

AN4-12

Bolt

**

Location

Loc Qty

Loc Code

ST357

53

118626

28

119775

25

118626

AN310-4 Purchased No

100 Each 61.0000 3 3

AN310-4

NUT

**

Location

Loc Qty

Loc Code

ST344

61

119328

1

119799

10

120124

50

120124

AN310C4 Purchased No

100 Each 33.0000 2 2

AN310C4

Nut

**

Location

Loc Qty

Loc Code

ST344

33

118626

8

119324

25

118626

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 79026

79026

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

5,685.000

6

6

MS21042L 3

Nut

**

Location

Loc Qty

Loc Code

ST300

5685

117441

16

117885

32

118451

5

118927

3

119017

5164

119075

465

119017

MS21042L5

Purchased

No

100

Each

1,990.000

4

4

MS21042L 5

Nut

**

Location

Loc Qty

Loc Code

ST300

1990

116105

5

116548

43

117611

50

118179

392

119109

1500

118179

MS24665-151

Purchased

No

100

Each

347.0000

3

3

MS24665-151

Cotter Pin

**

Location

Loc Qty

Loc Code

ST309

347

17566

347

17566

January-18-12 3:15:03 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 79026

79026

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

218.0000

2

2

MS24665-300

Cotter Pin

**

Location

Loc Qty

Loc Code

GA

200

118234

200

ST309

18

116823

18

NAS1149F0432P

Purchased

No

100

Each

248.0000

6

6

NAS1149F0432P

Washer

**

Location

Loc Qty

Loc Code

ST275

248

120142

248

NAS1149F0563P

Purchased

No

100

Each

115.0000

4

4

NAS1149F0563P

Washer

**

Location

Loc Qty

Loc Code

ST275

115

117735

115

NAS1149F0332P

Purchased

No

100

Each

268.0000

8

8

NAS1149F0332P

WASHER

**

Location

Loc Qty

Loc Code

ST275

268

117735

37

119225

228

17317

3

119225

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 79026

79026

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

3,452.000

2

2

NAS1149C0432R

**

Washer

[Handwritten signature]

Location

Loc Qty

Loc Code

ST297

3452

117291

2452

119124

1000

117291

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

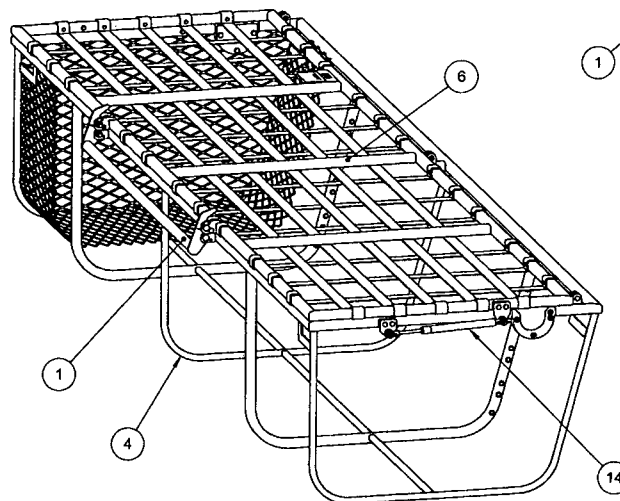
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

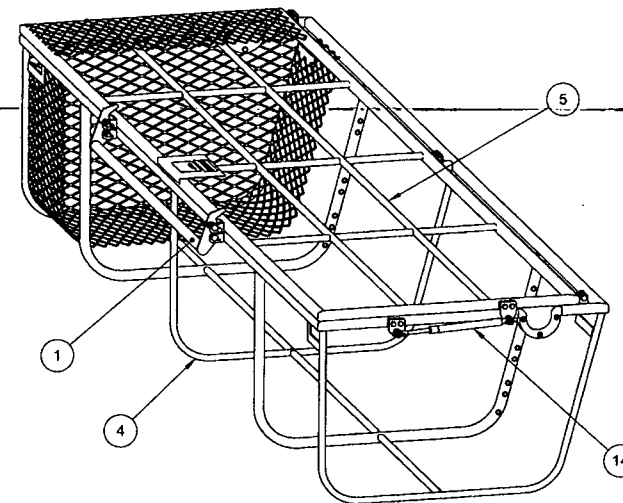
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	1	D3914-041	LONG BASKET LID ASSY (350)
6	1	1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2	2	AN3-16A	BOLT
17	2	2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	4	AN5-17A	BOLT
20	2	2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURNED
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 79.026-M.C.S
12/01/18

RELEASED
10.08.12.4
ECN 10-596

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (BB-1). QTY FOR ITEM #3 WAS 4 (D6-1). ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.08
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	JPH		
MFG. APPR.	JPH		
APPROVED	JPH		
DE APPR.	JPH		
DATE	10.07.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4030 TITLE LONG BASKET ASSY (350) REV. C SHEET 1 OF 3 SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

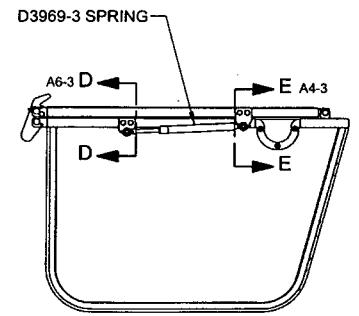
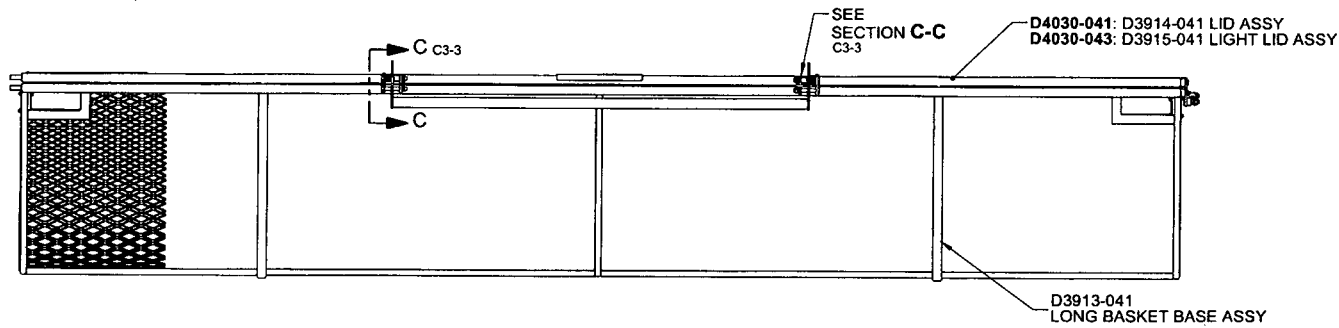
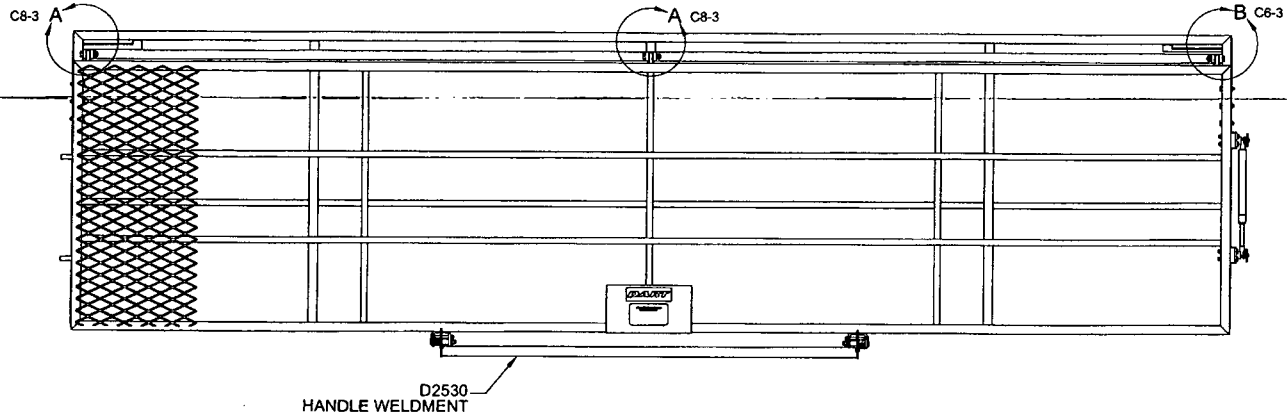
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NOTE: Date & initial all entries

79026



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP	DRAWING NO.	REV. C
CHECKED	JP	D4030	SHEET 2 OF 3
MFG. APPR.	SFS	TITLE	SCALE
APPROVED	JP	LONG BASKET ASSY (350)	NTS
DE APPR.	JP	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.07.23		

W/O:		WORK ORDER CHANGES					
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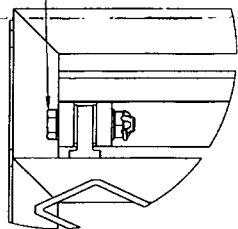
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

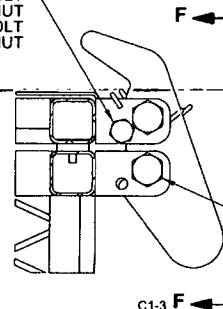
79026

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



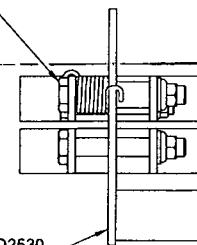
DETAIL A D8-2
D5-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530
HANDLE WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.12 4

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET-ASSY (350) NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries